

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000484**Date Inspected:** 10-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 114,Skin-B&E; 89**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the random observations related to the following;

ITEM-1 114 Skin-B, Stiffener Plate MP 1009. Filler welding was observed by Caltrans QA and was being performed by welder Bai Wenming (FCAW) with a travel speed of 234.28mm/min. Amps at 301 and Volts 29.8. Present were (BV) CWI Li Gang and ZPMC QC Wang Xzang Pin.

Item-2 114 Skin-E Welding of the filler passes on plate MP 1023-1 to MA 109-1 was in progress and was witnessed by this Caltrans QA. The welder operator was Xiang Huanfeng the Amps was recorded at 649, the Volts at 30.6 and the travel speed was 542.33 mm/min.

Item-3 89 Mock-Up SA 13-1 to P 1236-1 with a thickness of 75mm. The root had previously been welded, gouged and ground by ZPMC personnel. A thorough visual of the ground out areas disclosed no relevant indication and was found to be in compliance with project specifications.

Summary of Conversations:

There were no conversations pertinent to this project that took place during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer